








Work Order ID 60321


July 5, 2010 10:33:06 AM

Page 1

Item ID: D3916-5	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Light Rib				
Start Date: 7/05/10	Start Qty: 9.00		Cust Item ID:	
Required Date: 7/09/10	Req'd Qty: 9.00		Customer:	
Reference:				

Approvals:	Process Plan: <u>CL</u>	Date: <u>10/7/05</u>	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3916	A								

100

 Large Fab
 Large Fab

Memo
 1- Cut tube 50"
 2- Bend tube with manuel pipe bender as per DT9566
 *** Make line at 9.00" annd use jig for other line***
 3- Trim access tube material to finish size as per dwg D3916

SAD
 10-07-19

Pho →


110

 QC
 Quality Control

QC5- Inspect part completeness to step on W/O

Memo

S. Solari

(9)

120

 Packaging
 Packaging

Identify as per dwg & Stock Location: WA

Memo

SAD
 10-07-20

(9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 1D3916-5 PAR #: _____ Fault Category: Large fms NCR: Yes No DQA: 1 Date: 10/17/20
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: check Date: 10/17/20

NCR: 60321		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/17/19	#100	Found qty x1 Rib b re belt too short. RL not clamped correctly when trimming. Loe	<u>JB</u> <u>CHEN</u>	→ Scrap + Destroy qty x1 Replace m+ <u>M115034</u> qty x1	<u>SAD</u> <u>10-07-19</u>	<u>S</u> <u>10/07/19</u>	<u>JB</u> <u>CHEN</u>	<u>S</u> <u>10/17/19</u>

NOTE: Date & initial all entries

Work Order ID 60321

July 5, 2010 10:33:06 AM



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Item ID: D3916-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Light Rib

Start Date: 7/05/10

Start Qty: 9.00



Cust Item ID:

Required Date: 7/09/10

Req'd Qty: 9.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF
10-7-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

July 5, 2010 10:33:05 AM

Work Order ID: 60321

Parent Item: D3916-5

Parent Item Name: Light Rib



Start Date: 7/05/10

Required Date: 7/09/10

Start Qty: 9.00

Required Qty: 9.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
as per dwg revA 10.03.15 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TS0.500W.049

Purchased

No

100

f

317.0184

4.166

39.46737



Square Tubing



SAD

10-07-19

Location

Loc Qty

Loc Code

MAT

309.9221158

114004

0

114426

9.2647

114807

44.1709158

115034

256.4865

39.4674

MAT018

4.4738

114004

0.5

114161

3.9738

WA

2.62251

114724

2.62251

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

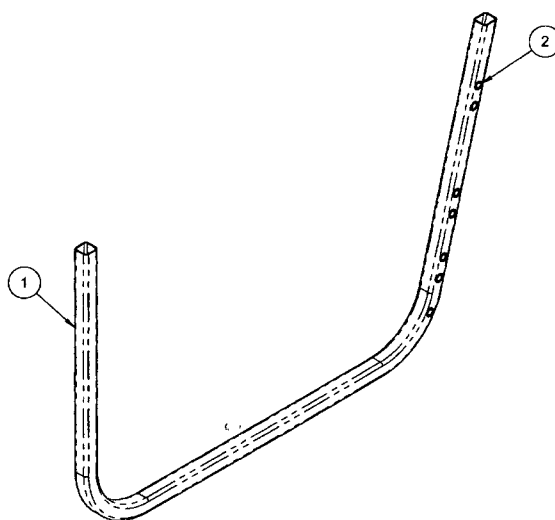
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

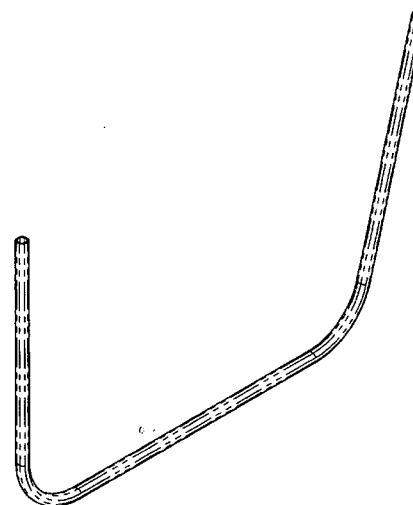
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



D3916-041 RIB ASSY

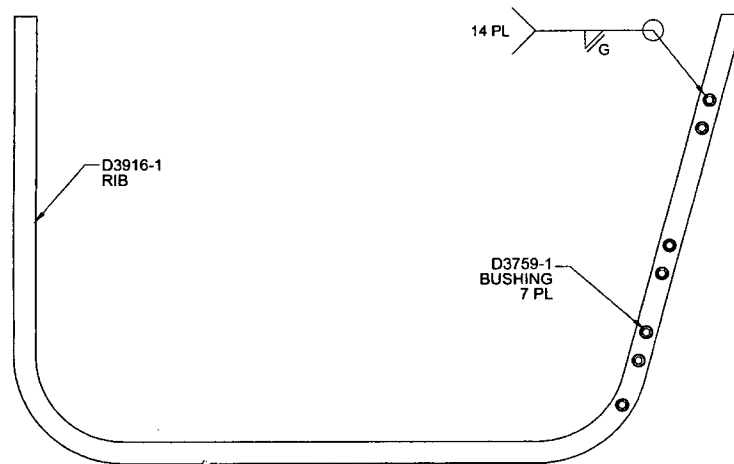


D3916-5 LIGHT RIB

C21017105
W10: 60321

RELEASED
2010-03-12
JMP

A NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	D3916	SHEET 1 OF 4
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	RIB ASSY, 350 BASKET	NTS
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D3916-041 RIB ASSY

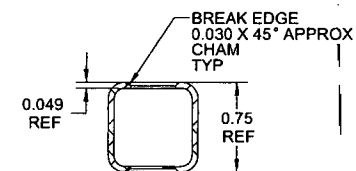
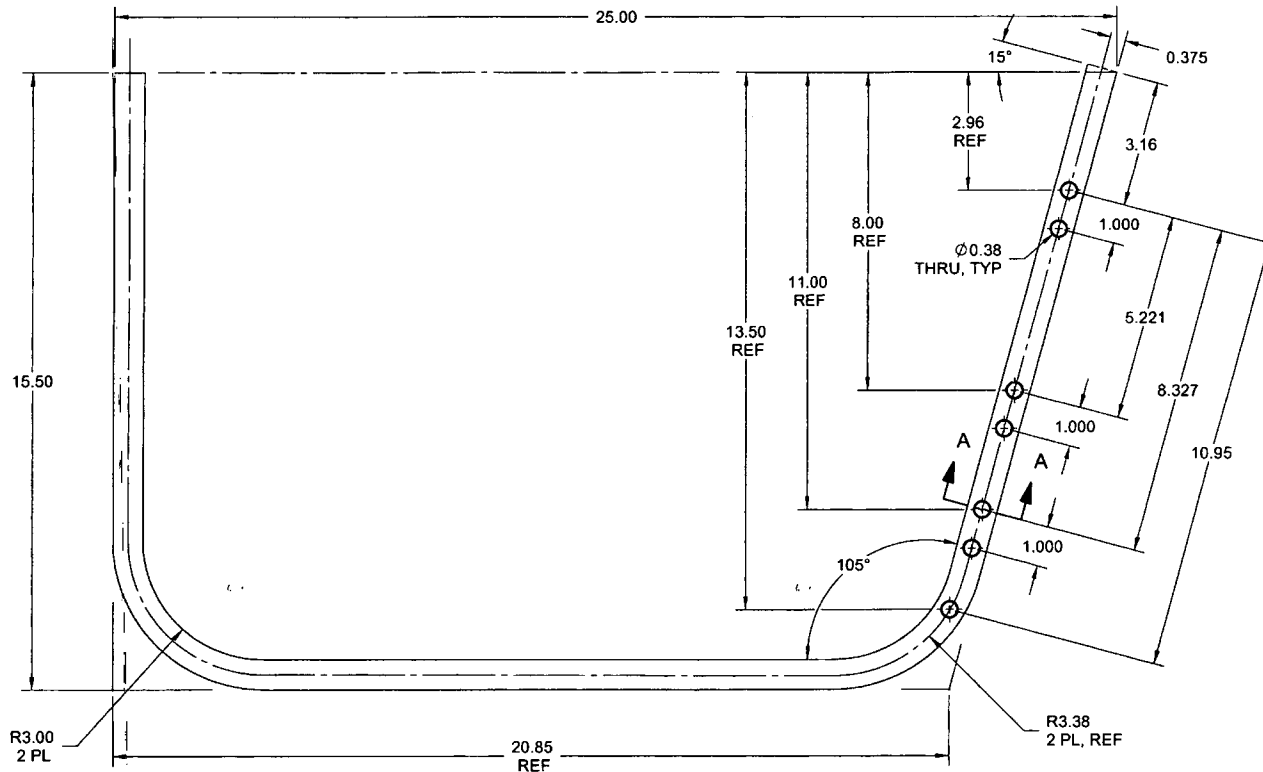
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

w10: 60321

RELEASED
2010-03-12
MP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	JP	D3916	SHEET 2 OF 4
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SECTION A-A

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2010-03-12
WPA

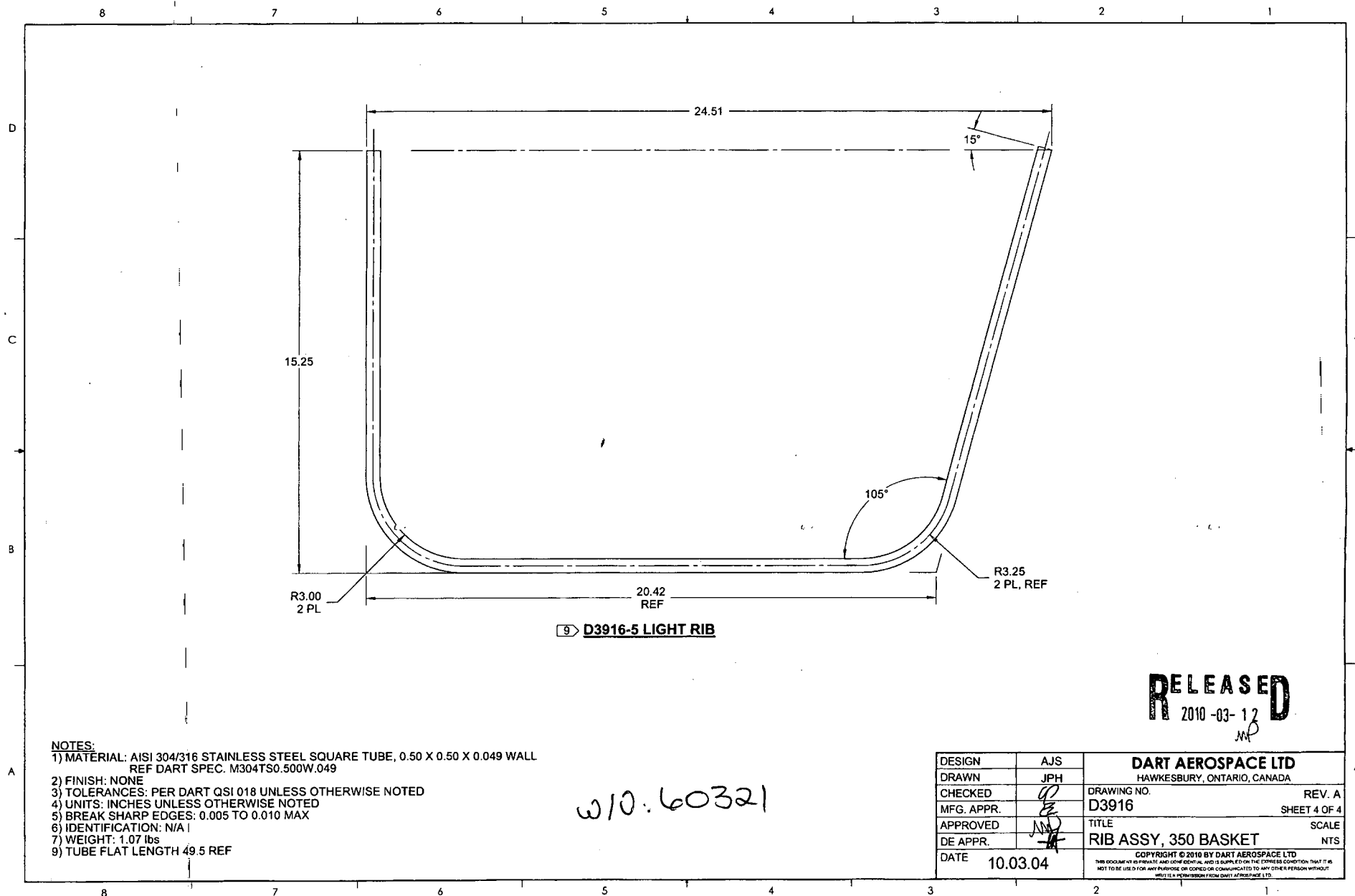
9 D3916-1 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.76 lbs
- 8) TUBE FLAT LENGTH 50.0 REF

W10! 60321

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	GP	DRAWING NO. D3916	REV. A
MFG. APPR.	BE	SHEET 3 OF 4	
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RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

W/O. 60321

DESIGN	AJS	DART AEROSPACE LTD	
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APPROVED		TITLE	SCALE
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